

Work Order ID 56900

March 17, 2010 1:46:20 PM



Page 1

Item ID: D3696-041

Accept



Setup Start



Revision ID:

Item Name: Arm Assembly

Start Date: 12/03/2010 Start Qty: 4.00



Required Date: 26/03/2010 Req'd Qty: 4.00



Reference:

JM 10-03-16.

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

Operation Description

Set Up/ Run Hours

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3696

Rev C

100



Bandsaw

BAND SAW

0.00

JM 10-03-16

17.600"

0.00

JM 10-03-16

4 8

105



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MILL AS PER DWG AND FOLIO FA918
FOLIO REV: *C*
DWG REV: *C*

MW

10/04/29

4 8

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Run Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

MW

Draw
Rev.

10/04/29

Plan
Code

4

Accept
Qty

4

Reject
Qty

0

Reject
Number

4

Insp.
Stamp

4

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

M.A

10/04/29

4

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

H-BR 10-5-4

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Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



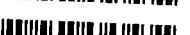
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112589

Memo

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

⇒ M 10/05/04 4 8

QC3- Inspect Part Finish

0.00

⇒ M-k 10/05/05 (4X)

160



QC

Quality Control

Memo

Small Fab

0.00

Memo

1-Install Helicoil 12-Press Bushing 13-Install Plunger

⇒ M-k 10/05/10 (4X)

170



Small Fab

Small Fab

(4X)

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Setup



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Item Name: Arm Assembly



Start Date: 12/03/2010 Start Qty: 4.00

Stop

Required Date: 26/03/2010 Req'd Qty: 4.00



Reference:

Cust Item ID:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Start

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/10/12

190



Packaging

Packaging

Identify as per dwg & Stock Location: 255

0.00

10/05/12

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/13

10/05/12

Picklist Print

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Page 1
2

Work Order ID: 56900



Parent Item: D3696-041



Parent Item Name: Arm Assembly

Comments:

IPP Rev:A New Issue 08-05-01 JLM Verified By:EC
IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Date: 12/03/2010

Start Qty: 4.00

Required Date: 26/03/2010

Required Qty: 4.00

Component Item ID/
D3799-1



Oilite Bronze Bushing

Replacement

Mfg/

Bin

Primary

Last

Route

Unit of
Each

Qty on
52.0000

Remaining
4.0000

Qty

Date

Status

D3801-3



Hand Retractable Spring Plunger

Manufactured

No

Warehouse

Location

Main Warehouse

ST088

44915 ✓

Loc Qty

Loc Code

52

52

Each

16.0000

4.0000



Hx M-k w/05/10

M7075T6B1.000X1.000



7075 T6 BAR 1.00 x 1.00

Purchased

No

Warehouse

Location

Main Warehouse

ST088

55571 ✓

Loc Qty

Loc Code

16

16

f

4.0700

6.1231



*Hx M-k
w/05/10*

7075T6B1.000X1.000



Warehouse

Location

Main Warehouse

MAT

107984

Loc Qty

4.07

4.07

7075T6B1.000X1.000

Mat 114415 → 6,1231

6,1231 → 10/03/24

DP 10/04/28

Picklist Print

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IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ MS21209C8-20	Replacement Barcode	Mfg/ Purchased	Bin No	Primary Last	Route	Unit of Each	Qty on 152.0000	Remaining 4.0000	Qty Barcode	Date	Status
Heli Coil Insert											

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST305	152	
108066	152	

4X M-f
b/05/10

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Shop Packet Print

Page 2

DART AEROSPACE LTD	Work Order:	56900
Description: Arm	Part Number:	D3696-1
Inspection Dwg: D3696	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>MM</u>	Audited by: <u>MMF & A</u>	Prototype Approval:	N/A
Date: <u>10/04/29</u>	Date: <u>10/04/29</u>	Date:	N/A

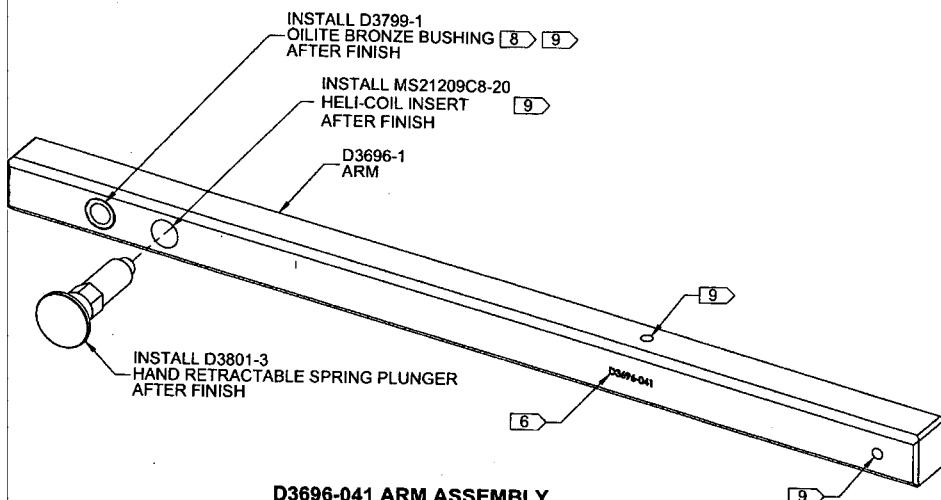
Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	<i>[Signature]</i>

ITEM	QTY	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50900

BS 10-3-12

RELEASED
06/27/11



D3696-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.69 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

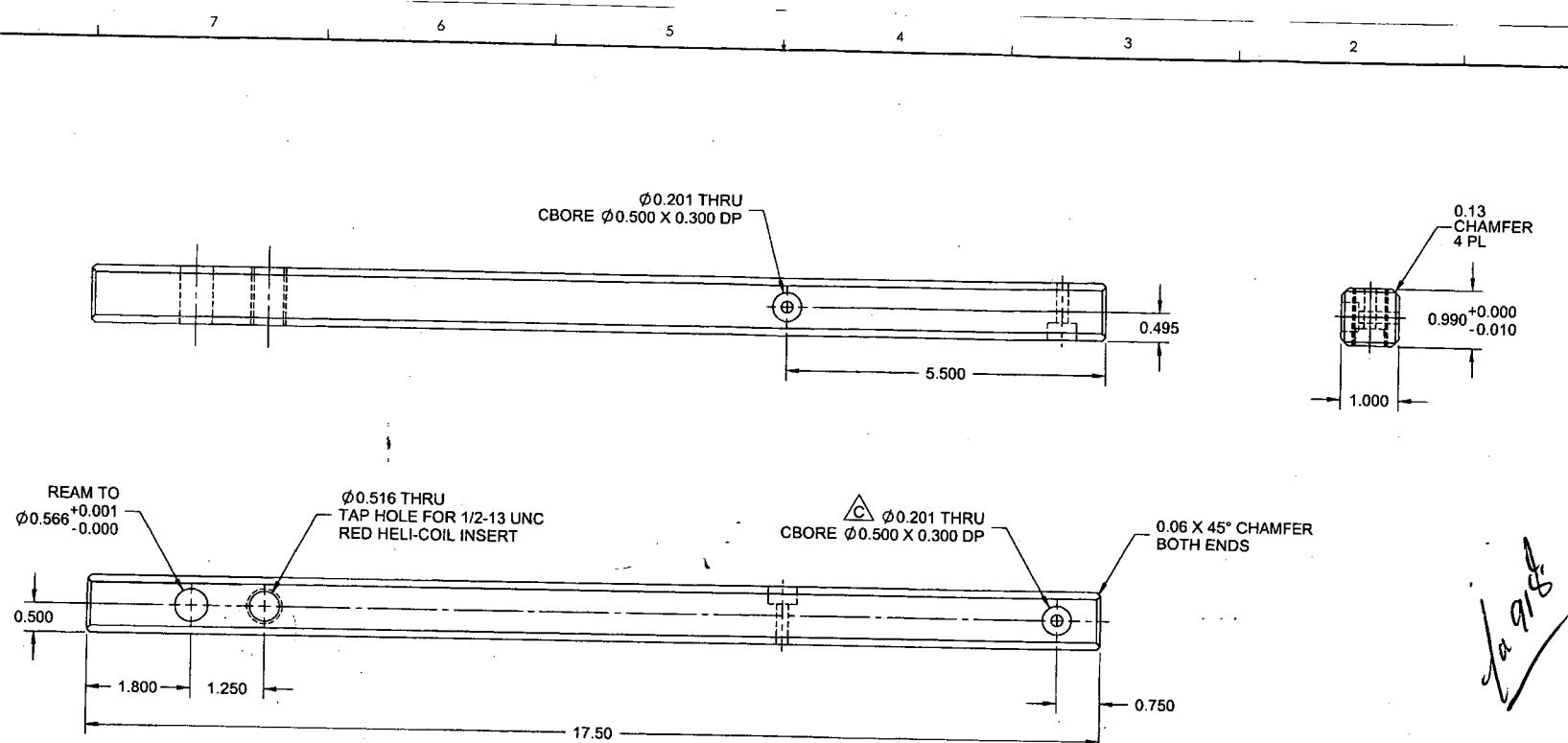
C	REVISED ITEM 5 AS FOLLOWS: Ø0.201 THRU CBORE Ø0.500 X 0.300 DP WAS 2 PI. (ZN C2-2). REASON: REDESIGNED ARM TO CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1). P/N D3801-3 WAS PRT-12 (ZN C2-2). PURCHASED PARTS NOW PROCURED THROUGH D3799-1. REVISED CBORE AND CUSHION DRAWINGS. ADDED Ø0.201 HOLE AND CBORE. (ZN C6-2 AND D5-2). 17.50 WAS 19.50 (ZN B5-2). 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2). POCKETS REMOVED. REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JK</i>	DART AEROSPACE LTD	
DRAWN	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JKS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JK</i>	D3696	SHEET 1 OF 2
APPROVED	<i>JK</i>	TITLE	SCALE
DE APPR.	<i>JK</i>	ARM ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3696-1 ARM

w/556900

RELEASED
01/09/14

D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.63 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3696
MFG. APPR.		REV. C
APPROVED		SHEET 2 OF 2
DE APPR.		TITLE
DATE	09.06.17	SCALE
		NTS
ARM ASSEMBLY		

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries